



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18601

Job Sheet 184442



Part No: RBT18601

Job Qty: 4 ea

Part Name: Main Rotor Swashplate ReGreasing Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 11/16/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: IPP Rev.A 17.09.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Waterjet		2 18/10/12
110	Waterjet - B4B	4 pcs	11/16/18	11/16/18	0.00	0.40	Waterjet 2 OMAX		2 18/10/12
130	CNC Vertical Machining	4 pcs	11/16/18	11/16/18	0.00	4.00	MORI NV5000-1		J.C.L.
140	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-4		J.C.L. 18-11-23
150	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-4		18-11-28
170	Outsource	4 pcs	11/16/18	11/16/18			GRO002-VC	8	18-11-28
180	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		NOV 30 2018
190	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC6		NOV 30 2018 68
200	Small Fab	4 pcs	11/16/18	11/16/18	0.00	1.00	Small Fab-7		DAS 9-89
210	QC	4 pcs	11/16/18	11/16/18	0.00	0.00	QC5		38
220	Packaging	4 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		9-89
230	QC21-FG	4 Ea	11/16/18	11/16/18	0.00	0.00	QC21		18/11/30

Part Op 110 - 1-Cut as per Dwg ***CUT QTY2 PER ASSEMBLY*****Identify each pair as per notes*** Dwg Rev: 1C Prog
Descriptions: Rev: 1C (Red Barn folder) 2-Deburr if necessary

130 - Machine as per DWG. Folio FB 65811 DEBURR ***Identify each pair as per notes***

170 - Issue P/O to GROUPE ALTECH; PO 041559 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2
CLASS-2, Water sealant -Material type; -Certificate of Conformity is required

200 - Assemble as per DWG and cut packings at split line as per notes.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	4.8000 ft (1.2 ea)	90-Start up Operation	5033404
0-345	345 O-Ring	4 Ea (1 ea)	200-Small Fab	5082410
0-353	353 O-Ring	4 Ea (1 ea)	200-Small Fab	5019337
13-14X3CSC	1/4 - 20 X 3 Socket Gap	8 Ea (2 ea)	200-Small Fab	5073631
15-GF637	1/4-28 45 Deg Short Grease Fitting	8 Ea (2 ea)	200-Small Fab	5073632

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S118722



Part: RBT18601

Job No: 184442

Serial No/Batch: S118722

Revision: 1C

Inspector:

Exp Date:

Instructions:

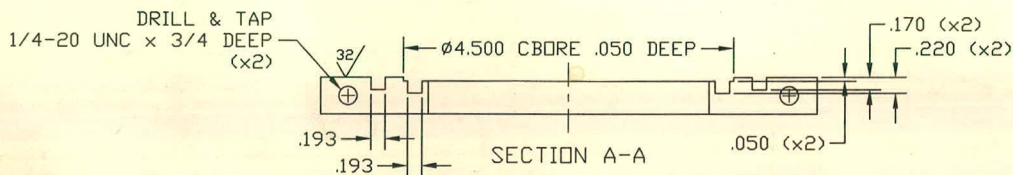
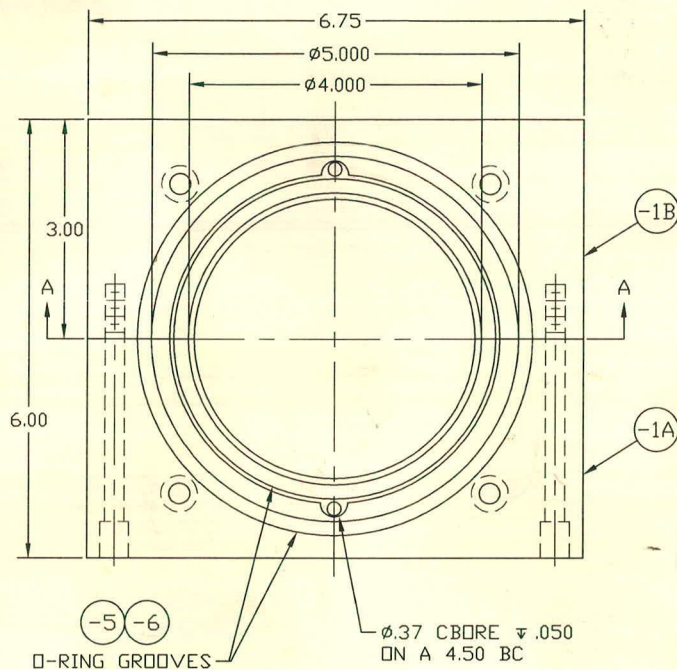
Date: 10/16/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.500X05.000	5	43	0
200-Small Fab	0-345	4	16	0
	0-353	4	16	0
	13-14X3CSC	8	26	0
	15-GF637	8	28	0
Part Specifications				
Specifications could not be found.				

Plex 10/10/18 7:17 AM dart.lacelle.linda

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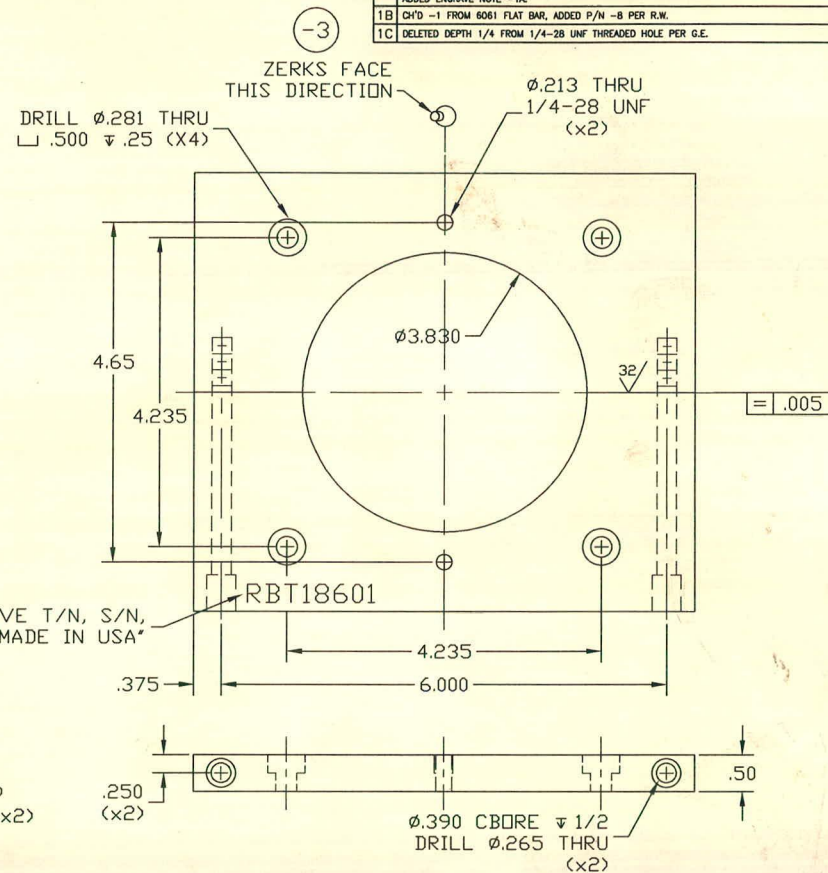
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED ZERK DIRECTION & CHANGE FROM 3-1/4 SHCS.	11/27/06		
1A	CH'D TITLE BLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, ADDED ENGRAVE NOTE -1A.	1/13/10	RJC	RW
1B	CH'D -1 FROM 6061 FLAT BAR, ADDED P/N -8 PER R.W.	6/23/11	RJC	RW
1C	DELETED DEPTH 1/4 FROM 1/4-28 UNF THREADED HOLE PER G.E.	5/23/12	RJC	GE



NOTES:

1. IDENTIFY EACH PAIR.
2. ASSEMBLE & CUT PACKINGS AT SPLIT LINE.

ASSY QTY	QTY	PART	QTY	DESCRIPTION	MATERIAL	B/D INFORMATION
		-1	2	SWASH PLATE	6061 FLAT BAR	1/2 x 3 x 6-3/4
		-3	2	ZERK		1/4-28 UNF x 45°
		-5	1	O-RING		2-345N70 345 BUNAN
		-6	1	O-RING		2-353N70 353 BUNAN
		-8	2	SOCKET HEAD CAP SCREW		1/4-20 UNC x 3



RED BARN MACHINE	
TITLE	SWASH PLATE REGREASING TOOL
DWG NO.	RBT18601
REV	1C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS FRACTIONS ANGLES UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL UNITS APPLY AFTER PLATING	DRAWN BY: CHRIS PARR APPROVED: <i>D. Med</i> ANODIZE RED USED ON MODEL MD-500 SCALE: NTS DATE: 3-16-01 SHEET: 1 of 1

DART AEROSPACE LTD		Work Order: 184 942
Description: SWASH PLATE REGREASING Tool		Part Number: RBT 18601
Inspection Dwg: RBT 18601 Rev: 1c		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.75	± 0.010	6.74	✓		Caliper	JCL-08
5.000	± 0.005	5.000	✓			
4.000	± 0.005	4.000	✓			
3.00	± 0.010					
6.00	± 0.010	6.000	✓			
4.500	± 0.005	4.500	✓			
0.050	± 0.010	0.052	✓			
0.170	± 0.005	0.173	✓			
0.220	± 0.005	0.223	✓			
0.193	± 0.005	0.193	✓			
0.193	± 0.005	0.193	✓			
0.281	± 0.006 -0.001	0.283	✓			
0.500	± 0.008 -0.001	0.500	✓			
0.25	± 0.010	0.252	✓			
4.65	± 0.010	4.653	✓			
4.235	± 0.005	4.235	✓			
4.235	± 0.005	4.235	✓			
1/4-28 UNF	2B	O.K.	✓		Go NO-GO	
6.000	± 0.0005	6.000	✓		Caliper	JCL-08
0.390	± 0.006 -0.001	0.389	✓			
1/2	± 0.031	0.499	✓			
0.265	± 0.006 -0.001	0.266	✓			
0.870	± 0.002 -0.001	0.870	✓			
1/4-20 UNC	2B	O.K.	✓		Go NO-GO	

Measured by: JCL	Checked by: [Signature]	QC Inspector:
Date: 18-11-23	Date: 18-11-23	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
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PURCHASE ORDER **PO041883**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041883
PO Date: 11/28/18
Due Date: 12/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

**revised PO*

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178970	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	-	11/30/18	5 pcs	0 pcs	5 pcs	\$5.80/pcs	\$29.00
Line Item Note ** ASAP by Friday morning **											
2	184442	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	11/30/18	8 pcs	0 pcs	8 pcs	\$5.80/pcs	\$46.40
Line Item Note ** ASAP by Friday morning **											

8x NOV 30 2018 *[Signature]*



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PURCHASE ORDER **PO041883**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185913	C45-1-1	Manual Knob Release -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required As Per DWG C45-1-1	Firmed	-	11/30/18	10 pcs	0 pcs	10 pcs	\$5.80/pcs	\$58.00

10 x NOV 30 2018

Line Item Note ** ASAP by Friday morning **

4	185767	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00
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PURCHASE ORDER **PO041883**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	185768	646.3813	AS350 Strut Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00
6	186252	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	12/6/18	20 pcs	0 pcs	20 pcs	\$7.70/pcs	\$154.00
7	186245	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	-	12/11/18	16 pcs	0 pcs	16 pcs	\$7.70/pcs	\$123.20



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PURCHASE ORDER **PO041883**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185766	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.65/pcs	\$153.00
9	185799	646.9710	Body Issue P/O to ATG : Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	12/6/18	10 pcs	0 pcs	10 pcs	\$15.60/pcs	\$156.00
10	186661	RBT112800-1	Base -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	-	12/6/18	13 pcs	0 pcs	13 pcs	\$5.80/pcs	\$75.40
Grand Total:										\$1,083.00	



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PURCHASE ORDER PO041883

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/30/18 10:12 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916656

Date: 29-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 8 ea	Part: RBT18601 Main Rotor Swashplate ReGreasi Red Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24225	Rev: 1C PO: PO041883 Line: 2	
✓ 10 ea	Part: C45-1-1 Manual Knob Release Red Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 24226	Rev: 3 PO: PO041883 Line: 3	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>29/11/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

